

Date: Wednesday, 2/15/2006 3:49:09 PM
 User: Kim Johnston

Process Sheet

SPLIT-#

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DART 13 MAN SHOULDER HARNESS KIT (4 POINT)
Job Number	: 25853		
Estimate Number	: 10391		
P.O. Number	: N/A	Part Number	: D412702021
This Issue	: 2/15/2006 S.O. No. : N/A	Drawing Number	: IIN-D412-702 PG 11
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 25482	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/2/2006 Qty: 2 Um: Each
Checked & Approved By	: [Signature] 06.02.16		
Comment	: Est Rev:B Removed Manufacturing 05-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-702-021 CHG001

DH 06/02/28

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3195041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3195-041 Bracket B25807 ✓

4.0	D3195043	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3195-043 Bracket B25201 2mc1

5.0	D31961	Bar
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

1 D3196-1 Bar B25849

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:49:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13 MAN SHOULDER HARNESS KIT (4 POINT)

Job Number: 25853

Part Number: D412702021

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D31963	Bar
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

1 D3196-3 Bar B24130 ✓

7.0	D31964	Bar
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

1 D3196-4 Bar B24131 ✓

8.0	D3197041	Bar Assembly
-----	----------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3197-041 Bar B25939 ✓

9.0	D31981	Fitting
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 D3198-1 Fitting B25102 ✓

10.0	D32681	Placard
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

2 D3268-1 Placard B25103 ✓

11.0	D3446041	Harness Assembly
------	----------	------------------



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

9 D3446-041 Harness Assembly B25175 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:49:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13 MAN SHOULDER HARNESS KIT (4 POINT)

Job Number: 25853

Part Number: D412702021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3446043

Harness Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 D3446-043 Harness Assembly

B25176 -

13.0

AN45A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 AN4-5A

Bolt

M10089 -

14.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

4 AN4-13A

Bolt

M18369 -

15.0

AN420A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

8 AN4-20A

Bolt

M14855 -

16.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

20 AN960JD416

Washer

M19085 -

17.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M17992 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 06/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:49:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13 MAN SHOULDER HARNESS KIT (4 POINT)

Job Number: 25853

Part Number: D412702021

Job Number: 

Seq. #: Machine Or Operation: Description :

18.0 MS24694S152 Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit]

Qty Part Number Description Batch

8 MS24694-S152 Screw

M10244 2mcr

M18637 1ymcr

P 6/3/6

19.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206103/06

(1)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-021

Location: Draft

C 206103/06

(1)

21.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06103/06 (1)

Job Completion

LL



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -021	QTY -023	QTY -025	QTY -027	Part Number	Description
X				D412-702-021	Dart 13-Man Shoulder Harness Kit, 4-point
	X			D412-702-023	Dart 5-Man Shoulder Harness Kit, 4-point
		X		D412-702-025	Dart 4-Man Aft Facing Shoulder Harness Kit, 4-point
			X	D412-702-027	Dart 4-Man Side Facing Shoulder Harness Kit, 4-point
2	2			D3195-041	Bracket
2	2			D3195-043	Bracket
1	1			D3196-1	Bar
1			1	D3196-3	Bar
1			1	D3196-4	Bar
2	2			D3197-041	Bar
4		4		D3198-1	Fitting
9	5		4	D3446-041	Harness Assembly, 4 point
4		4		D3446-043	Harness Assembly, 4 point
2	2			D3268-1	Placard
4		4		AN4-5A	Bolt
4	4			AN4-13A	Bolt
8		8		AN4-20A	Bolt
20		20		AN960JD416	Washer
12		12		MS21042L4	Nut (or MS21042-4)
8	2		6	MS24694-S152	Screw

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 25853

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3196-1
Job Number	: 29986	Part Number	: D31961
Estimate Number	: 10804	Drawing Number	: REWORK-ECN871
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 15/12/2006	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 22/12/2006
Previous Run	: 00015	Type	: MACHINED PARTS
Written By	:	Qty:	16
Checked & Approved By	:	Um:	Each
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-REMOVE FROM STOCK:

D3196-1 325848 8X

325/08 1X

325/00 1X

franklts (1-X)

D412-702-021 326883 3X

325853 1X

D412-702-023 326074 3X

325705 2X

D412-702-033 327935 1X

(AND FROM WIP)

D412-702-011

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE ALL D3196-1'S FROM KITS

3.0

D31961

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)

Bar

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

REWORK D3196-1

PER ECN 871

Signature

06/12/18

16

Date: Friday, 15/12/2006 9:48:32 AM
 User: Linda Lacelle

Process Sheet

D412-702-021 B25883

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3196-1
Job Number : 29986 <i>12</i>	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D31961
This Issue : 15/12/2006 S.O. No. : <i>N/A</i>	Drawing Number : REWORK-ECN871
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : <i>N/A</i>
Previous Run : 00015	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 22/12/2006 Qty: <i>16</i> Um: <i>18</i> Each
Checked & Approved By : <i>[Signature]</i>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

-REMOVE FROM STOCK:

D3196-1 B25849 8X

B25108 1X

B25100

1X franklts (1-X)

D412-702-021 B26883 3X B25853 1X (4)

D412-702-023 B26074 3X ~~B2772~~ 1X B25765 2X (5)

D412-702-033 327 935 1X (1)

(AND FROM WIP)

D412-702-011

P64/12/15

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

REMOVE ALL D3196-1'S FROM KITS

3.0	D31961	Bar
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
 Bar

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

REWORK D3196-1

PER ECN 871

06/12/18

16

Date: Thursday, 12/10/2006 2:56:32 PM
 User: Linda Lacelle

Process Sheet

D412-702-021 B25853

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D412-702

Job Number : 28952

*Estimate Number : 10804

P.O. Number : N/A

Part Number : Z_CUSTOM

This Issue : 12/10/2006 S.O. No. : N/A

Drawing Number : UPDATE PAPERWORK

Prsht Rev. : NC

Project Number : N/A

First Issue : N/A Type : OVERHEAD

Drawing Revision : N/A

Previous Run : 00015

Material : N/A

Written By : _____

Due Date : 19/10/2006 Qty: 1 Um: Each

Checked & Approved By : _____

Comment : _____

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE KITS FROM STOCK

D412-702-011

D412-702-013

D412-702-021 B268830 B25853 1X

D412-702-023 B2576520 B26074 34

D412-702-033 1X B27935

ADD NEW PAPERWORK DSI 9354 REV.A

P. 06/10/20

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RETURN TO STK

P. 06/10/20

3.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P. 06/10/20

Job Completion



U Do. W. 26